

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 4293 (1984): U-type Clamps [PGD 2: Machine Tool Elements and Holding Devices]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Indian Standard
SPECIFICATION FOR
U-TYPE CLAMPS
(Second Revision)

1. Scope — Specifies the dimensions and materials for two types of U-type clamps used in holding work pieces in place when they are being machined.

2. Types

Type A — U-Type clamps without finger.

Type B — U-Type clamps with round finger.

3. Dimensions

3.1 Dimensions for U-type clamps, Type A shall be as given in Table 1.

3.2 Dimensions for U-type clamps, Type B shall be as given in Table 2.

4. Designation — A U-type clamp of Type A having $d=14$ mm and $l=125$ mm shall be designated as :

U-Type Clamp A 14X125 IS : 4293

5. Material — Steel suitably hardened and tempered to a tensile strength of 750 to 850 N/mm².

6. Finish — The U-type clamps shall be free from cracks, burrs, pits and other defects. These shall also be free from sharp corners.

7. Preservation and Packing

7.1 A suitable anti-corrosive surface treatment shall be given to U-type clamps.

7.2 The U-type clamps shall be packed in accordance with best trade practice.

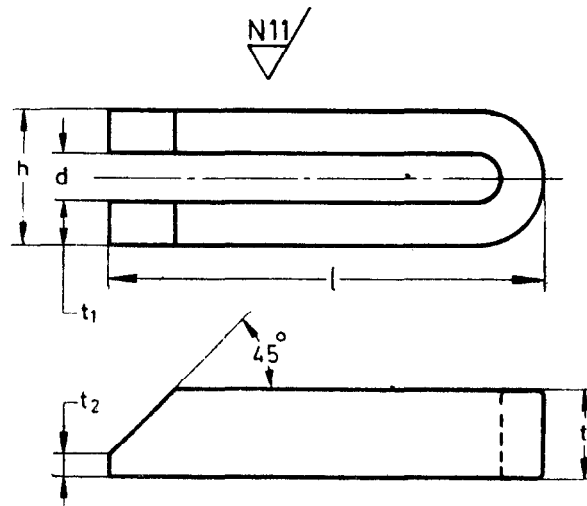
8. Marking

8.1 The U-type clamps shall be marked at an appropriate place with the designation and manufacturer's name or trade-mark.

8.2 ISI Certification Marking — Details available with the Indian Standards Institution.

TABLE 1 DIMENSIONS FOR U-TYPE CLAMPS, TYPE A
(*Clauses 2 and 3.1*)

All dimensions in millimetres.



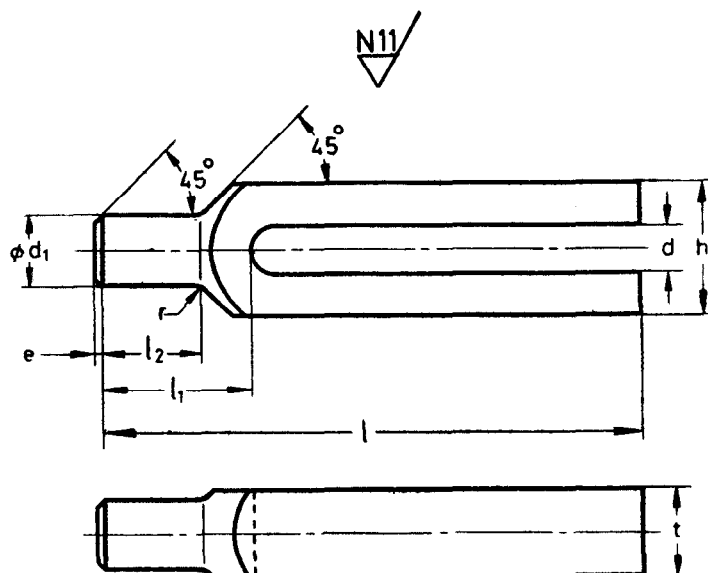
d H13	l	t	t_1	t_2	h approx	For Screw Size
6.6	60	12	6	3	19	M 6
9	80	15	8	4	25	M 8
11	100	20	10	5	31	M10
14	125	25	12	6	38	M12
	(160)					
	(200)					
18	160	30	15	8	48	M16
	(200)			10		
	(250)					
22	200	40	15	10	52	M20
	(250)				62	
	(315)					
26	(200)	40	20	10	66	M24
	250					
	(315)					
33	(250)	50	20	12	74	M30
	315					
	(400)					

Note 1 — Values given within brackets are non-preferred.

Note 2 — Dimensional deviation for untoleranced dimensions : Coarse class according to IS : 2102 (Part 1) - 1980 'General tolerances for dimensions and form and position; Part 1 General tolerances for linear and angular dimensions (*second revision*)'.

TABLE 2 DIMENSIONS FOR U-TYPE CLAMPS, TYPE B
(*Clauses 2 and 3.2*)

All dimensions in millimetres.



d H13	d_1	e	t	l	l_1	l_2	r	h	For Screw Size
6.6	12	1.0	15	80	28	18	2.5	25	M 6
9	16		20	100	30			30	M 8
11				125	36	24		30	M10
14	20	1.5	25	160 (200)	45	30	5.0	40	M12
18	24	1.5	30	200 (250)	55	36	5.0	50	M16
22	30	2.0	40	250 (315)	65	45	5.0	60	M20
26	38	2.0	40	(250) 315	80	56	5.0	70	M24
33	45	2.0	50	(315) 400	85	56	5.0	80	M30

Note 1 — Values given within brackets are non-perferred.

Note 2 — Dimensional deviation for untoleranced dimensions : Coarse class according to IS : 2102 (Part 1)-1980.

EXPLANATORY NOTE

This standard was first revised in 1975. The committee responsible for formulation of this standard decided to revise the same again to bring it in line with other standards on clamps, which are also being revised in respect of materials, tolerance, roughness values and rationalization of sizes.